

642-512

Date: Wednesday, 13/05/2009 11:30:45 AM  
User: Julie Dawson

# Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: FLOAT SKIDTUBE ASSEMBLY
<b>Job Number</b>	: 47939A		
<b>Estimate Number</b>	: 10309		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D206642541
<b>This Issue</b>	: 13/05/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3274 REV D
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 47938A	<b>Drawing Revision</b>	: D
		<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 29/05/2009
<b>Checked &amp; Approved By</b>	: <u>JU09-05-13</u>	<b>Qty:</b>	1 Um: Each
<b>Comment</b>	: Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM Est Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM Est Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD Est Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC Est Rev:F 08-06-02 add comment DD verified by:EC Est Rev:G 08-10-09 revise details DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
<b>Comment:</b> DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D206-642-541 CHG003 <i>N/A</i> <i>JA</i>		
2.0	D26001190	Extrusion Round 3" 206
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2600-1-190 3" OD Tube <i>D-47575</i> <i>MB 09-06-01</i> <i>Q</i>		
3.0	D32851	Cap
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3285-1 Fwd Cap <i>D-47635</i> <i>BE 09-06-01</i>		
4.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
<b>Comment:</b> LANDING GEAR RESOURCE 1  1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274, cut fwd end of tube with saw table setup D3274.  2- remove fwd indexing ridge as per dwg D3274. Prepare for welding <i>U 9-6-1</i>		

*MB 09-06-01 Q*

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Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 47939A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch:

*m111679/m109213 BE 09/06/01*

4- grind fwd cap weld on top surface only

*BE 09/06/01*

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

*AWM 9-6-3*

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1

*Pr 09-06-03*

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*09/06/03*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*09/06/03*

8.0

D3282041

Float Web (206L/407)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web

*B47963 ① 4 9-6-3*

9.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

*- AWM 9-6-3*

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Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 47939A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291

111557

Sikaflex expire date:

10-1-20

Start: 9-6-3

Time: 4:20

Finish: 9:04

Time: 7:45 AM

(Adhere for 12 hours)

M 9-6-3

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/04

11.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

09-06-04

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2  
OPEN HOLES TO .297" . Deburr

M 9-6-4

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE  
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)  
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/04

13.0

D2649

Cross Bolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

12 D2649

Crossbolt spacer

845317

BE 09/06/04

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Job Number: 47939A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D32751

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D3275-1 Crossbolt spacer

48117 BE 09/06/04

15.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod

M109213 BE 09/06/04

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

Pm 09-06-05 (X)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/08 (X)

17.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/06/08 (X)

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

UMP 09/06/10 (X)

19.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

3:30pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

4:00pm

JSP 09-06-10 (X)

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Job Number: 47939A

Part Number: D206642541

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/06/11 0

21.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3415-041	Nut Plate	B33842

FL

22.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	CCR264SS3-3	Rivet	M111548

FL

23.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	CR3212-4-03	Rivet	M15984

FL

24.0

ALS71032130

Insert



Comment: Qty.: 78.0000 Each(s)/Unit Total : 78.0000 Each(s)

Insert

Batch: M110511

FL

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg.D3274. Apply LPS-3 to Nut Plate and rivets.

A/RN/ALPS-3 M104251

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

FL 09/06/11

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Job Number: 47939A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Sikaflex-291

Sikaflex expire date:

m11/557

10/01

FL 09/06/11 ①

26.0

QC5

INSPECT WORK TO CURRENT STEP



2020-10 ①



Comment: INSPECT WORK TO CURRENT STEP

Inspect Nut Plate & Inserts

27.0

AN3C4A

BOLT



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)

BOLT

Batch:

m11/819

FL

28.0

D353515

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B47521

FL

29.0

D353523

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B47522

FL

30.0

D353535

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B47524

FL

31.0

D353539

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B47525

FL

32.0

D353615

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch:

B47315

FL 09/06/11 ①

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Job Number: 47939A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

D353623

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B46884

FL

34.0

D353635

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B47524

FL

35.0

D353639

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B47714

FL

36.0

D35371

Wearpad



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

WEARPAD

Batch: B47715(x2) B48162(x7)

FL

37.0

D35373

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

Batch: B35697

FL

38.0

AN960C10L

washer



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description Batch

80 AN960C10L

Washer

M111808

FL

39.0

D36721

Phenolic Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch B42329

FL 09/06/11 ①

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Job Number: 47939A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3413-1

Ring

B33949.

*FX.*

41.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN4C5A

Bolt

M110552.

*FX.*

42.0

AN960C416

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960C416

Washer

M100993

*FX.*

43.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap

D46327

*FX.*

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

2-Install wearpads & gaskets as per Dwg D3274.

3-Install ring as per Dwg D3274

A/R Sikaflex-291

M111557

Sikaflex expire date:

10/01

4-Inspect for foreign objects as per QSI 024

5-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3

Batch:

N/A

*FX.* 09/06/11 ①



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Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R Sikaflex-291 W11557

Sikaflex expire date: 10/01

FZ 09/06/11 (1)

45.0

QC5

INSPECT WORK TO CURRENT STEP



0906-11 (1)



Comment: INSPECT WORK TO CURRENT STEP

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: PP 47939

09/06/11 (1)

47.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN <b>CP</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <b>[Signature]</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D3274</b>	REV. D SHEET 1 OF 4
DATE <b>06.12.19</b>		TITLE <b>SKIDTUBE ASSEMBLY</b>	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

**RELEASED**07.02.12 **[Signature]**

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

**GENERAL NOTES:**

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 TO ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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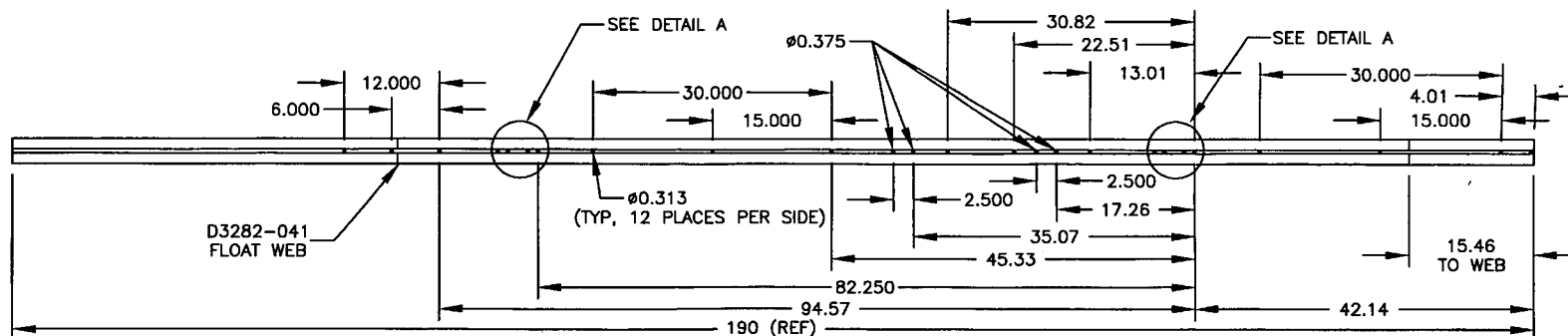
ALS7-1032-130

WORK ORDER

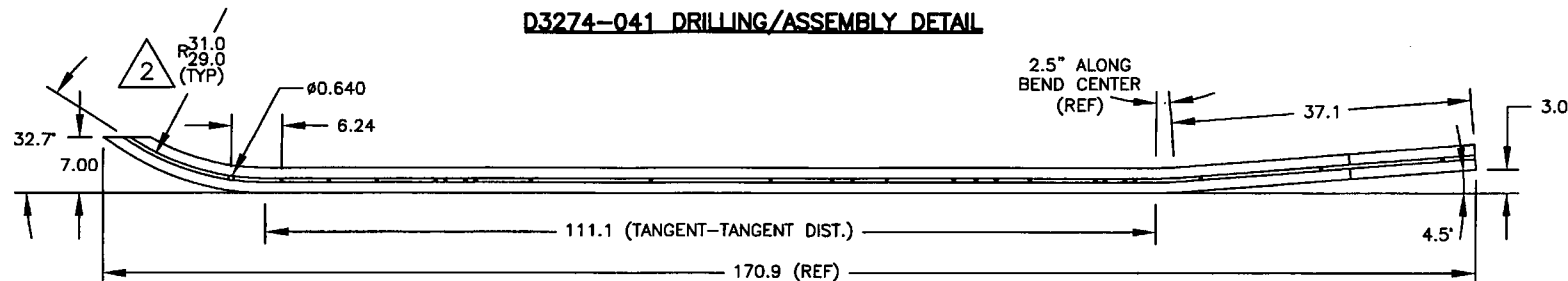
47939A

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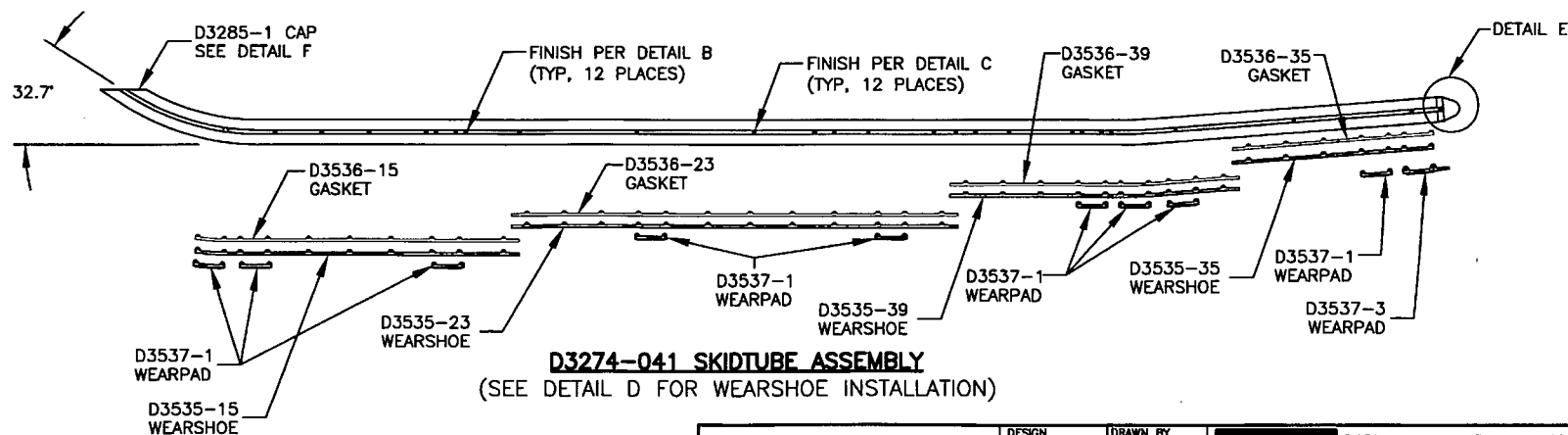
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**D3274-041 DRILLING/ASSEMBLY DETAIL**



**D3274-041 BEND/DRILLING DETAIL**



**D3274-041 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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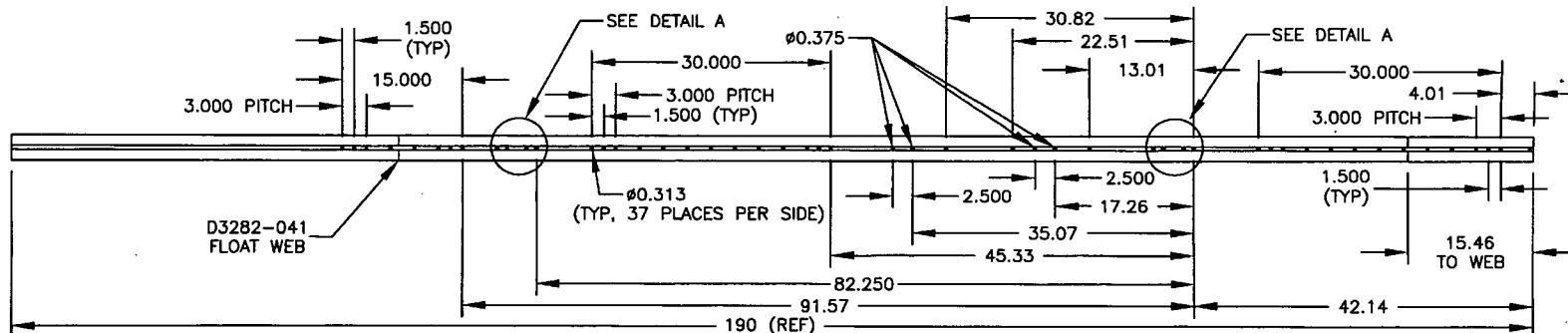
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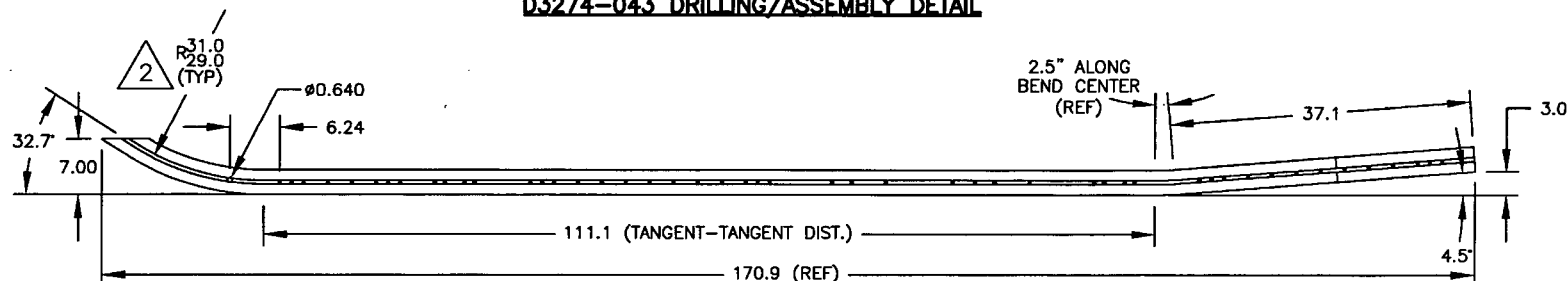
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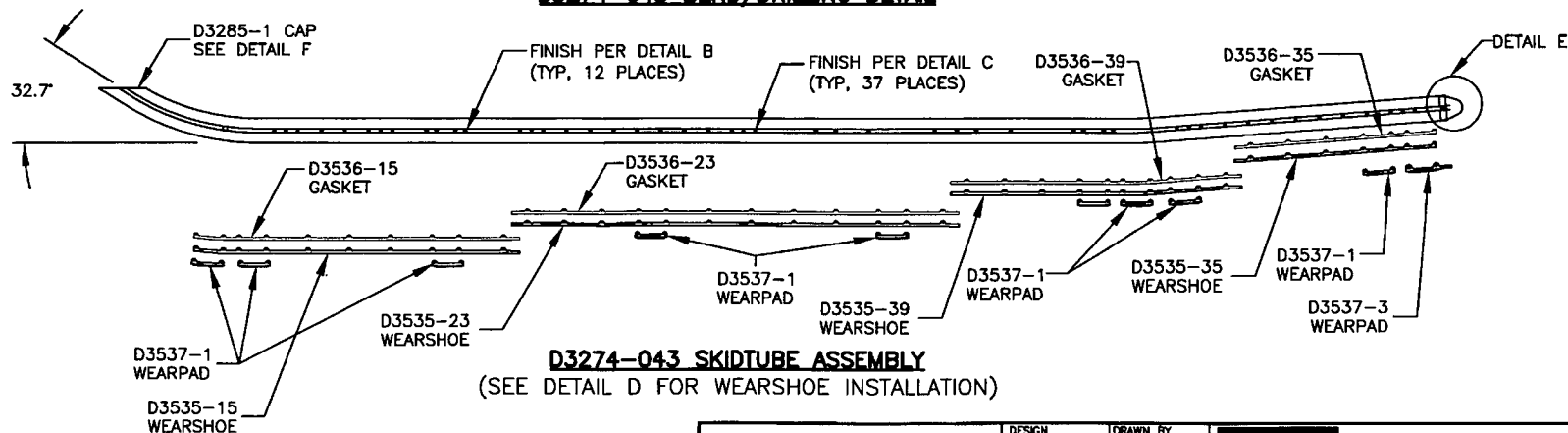
DESIGN	CP	DRAWN BY	PH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. D
CHECKED	#	APPROVED	#	DRAWING NO. D3274	SHEET 2 OF 4
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SCALE	1:15



**D3274-043 DRILLING/ASSEMBLY DETAIL**



**D3274-043 BEND/DRILLING DETAIL**



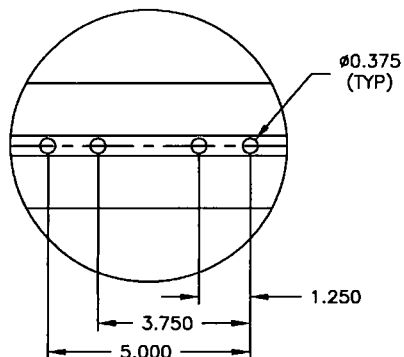
**D3274-043 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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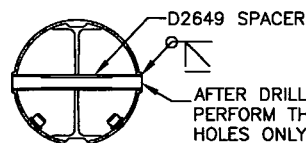
RELEASED  
07.02.12

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		DATE		TITLE SKIDTUBE ASSEMBLY	SCALE 1:15
		06.12.19			

### DETAIL A: DRILL DETAIL

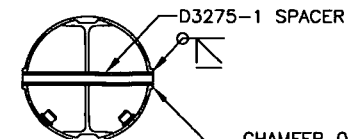


### DETAIL B FOR 0.375 HOLES ONLY



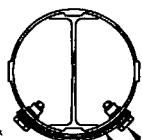
AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR 0.375  
HOLES ONLY:  
1. CHAMFER HOLE 0.030x45°  
2. INSERT D2649 SPACER  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C'BORE TO 0.313x0.75 DEEP

### DETAIL C FOR 0.313 HOLES ONLY



CHAMFER 0.030x45°  
(TYP)

### DETAIL D



ALS7-1032-130 INSERT (1)  
AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
(78 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

### DETAIL E

D2646 CAP  
SEAL WITH  
SIKAFLEX-241/291  
ADHESIVE

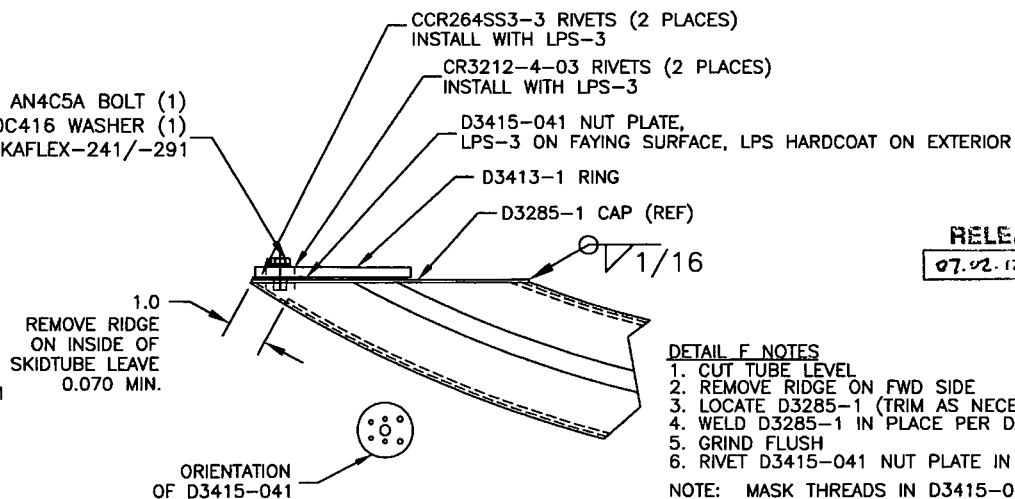
AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
NAS1515H3L WASHER (1)  
(2 PLACES)  
INSTALL WITH SIKAFLEX-241/-291

0.208 (2 PLACES)  
DRILL PRIOR TO INSTALLING  
D2646 CAP

BORE OUT END OF SKIDTUBE  
TO 0.75 DEPTH AND 0.070 WALL

0.400

### DETAIL F: END FINISHING DETAIL



### DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

RELEASED

07.02.12

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DESIGN  
CP  
CHECKED  
DATE  
06.12.19

DRAWN BY  
PH  
APPROVED  
DATE

**DART** DART AEROSPACE USA, INC.  
PORT HADLOCK, MA  
DRAWING NO.  
D3274  
TITLE  
SKIDTUBE ASSEMBLY  
REV. D  
SHEET 4 OF 4  
SCALE  
1:3

NO. 201

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 47927A  
Part number: D206 642 541  
Description: float tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual:  
Penetration:

pass[☒] fail[ ]  
pass[☒] fail[ ]

UNACCEPTABLE

Cracks:  
Undercut:  
Pin holes:  
Overlap (cold lap)  
Porosity (surface):  
Coloration:

pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]

Qualifier Pat. Dunt Date of Test Coupon 09-06-04  
Welder Barclay Elliott Date of Test Coupon 09-06-04

The above named individual is qualified in accordance with AWS D17.1.2001 to weld